

Date: Wednesday, 4/4/2007 9:01:16 AM  
 User: Kim Johnston

## Process Sheet

split w/lo  
 SB 02/08/14

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SCUFF PLATE  
 Job Number : 31604  
 Estimate Number : 11952  
 P.O. Number : N/A Part Number : D206555003  
 This Issue : 4/4/2007 S.O. No. : N/A Drawing Number : D206-555 REV C  
 Prsht Rev : NC Project Number : N/A  
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : C  
 Previous Run : 29020 Material : N/A  
 Due Date : 4/20/2007 Qty: 10 U/m: Each  
 Written By :  
 Checked & Approved By :  
 Comment : est rev C 99.06.29 returned to electro polish DM  
 Est Rev:D Now on Waterjet 06-10-25 JLM

Additional Product

Job Number:



CHG002

Seq. #

Machine Or Operation:

Description :

1.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555  
 using DT 8316-3

N/A 4/20/07-08-15

2.0

M304S25GA

304/316 .020" Sheet



Comment: Qty.: 0.4148 sf(s)/Unit Total: 4.1475 sf(s)

304/316 .020" Sheet 25GA

Batch: M103509

SAD 07/06/04

10

3.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D206-555

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

SAD 07/06/04 (10)

SAD

07/06/04

10

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/11

10

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

4-06-12 (10)



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 31604

Part Number: D206555003

Job Number:



Seq. #

Machine Or Operation:

Description:

1.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Finish form on bench forming Jig DT 8317-3

INSPECT WORK TO CURRENT STEP

QC5



Comment: INSPECT WORK TO CURRENT STEP

8.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services  
Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.  
Issue P/O: \_\_\_\_\_  
Possible supplier: TQF Technologies

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage  
Ensure certificate of conformity is attached

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Remove tooling tabs and deburr

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 31604

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description:

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.15

Job Completion



07.08.15



**DART**

DESIGN JB	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

**RELEASED**

06.09.19

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SUBJECT TO AMENDMENT

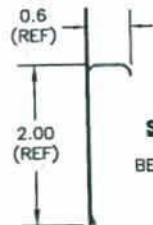
WITHOUT NOTICE

WORK ORDER

NO. 31604

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**SECTION C-C**  
DETAIL OF  
BENDING SHOWN

**DETAIL B**  
SCALE 1:1

REFER TO DETAIL B  
FOR 1:1 SCALE

16.000 (REF)

2.7  
(REF)

**FLAT PATTERN**

8.000

19.0  
(REF)

8.000

#0.187  
(3 PLACES)

**RELEASED**

06.09.19

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**D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)**  
**D206-555-004 (BEND OPPOSITE)**

**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY [Signature]	<b>DART</b> DART AEROSPACE LTD MISSISSAUGA, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED [Signature]	DRAWING NO. D206-555	SHEET 3 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 2:1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/14	6	Split w/o	SAS	07/08/14	(2)		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries